

# Work Order ID 91159

October-03-12 9:07:31 AM

**\*91159\***

Page 1

Item ID: D3286-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 03/10/2012 Start Qty: 120.00

**\*120\***

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 120.00

**\*120\***

Customer:

Reference:

Approvals: Process Plan: ML3

Date: 12-10-03 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3286	Rev A								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3286								
304.125"	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	<b>Memo</b>	0.00							
Quality Control									

DAS  
15  
12/11/20

ISO  
CNC



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Item ID: D3286-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 03/10/2012 Start Qty: 120.00

**\*120\***

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 120.00

**\*120\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/11/22 JF  
MK  
12-11-22

# Picklist Print

October-03-12 9:07:34 AM

Page 1

Work Order ID: 91159

\*91159\*

Parent Item: D3286-1

\*D3286-1\*

Parent Item Name: Doubler

Start Date: 03/10/2012

Required Date: 05/12/2012

Start Qty: 120.00

Required Qty: 120.00

## Comments:

IPP A04.07.14New issueKJ/JLM

IPP Rev:B Now on Waterjet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	197.0000	0.0749	9.461053			

\*M304S11GA\*

304/316 0.125 Sheet

\*\*

1712-11-8

## Location

## Loc Qty

## Loc Code

MAT020

197

122521

197

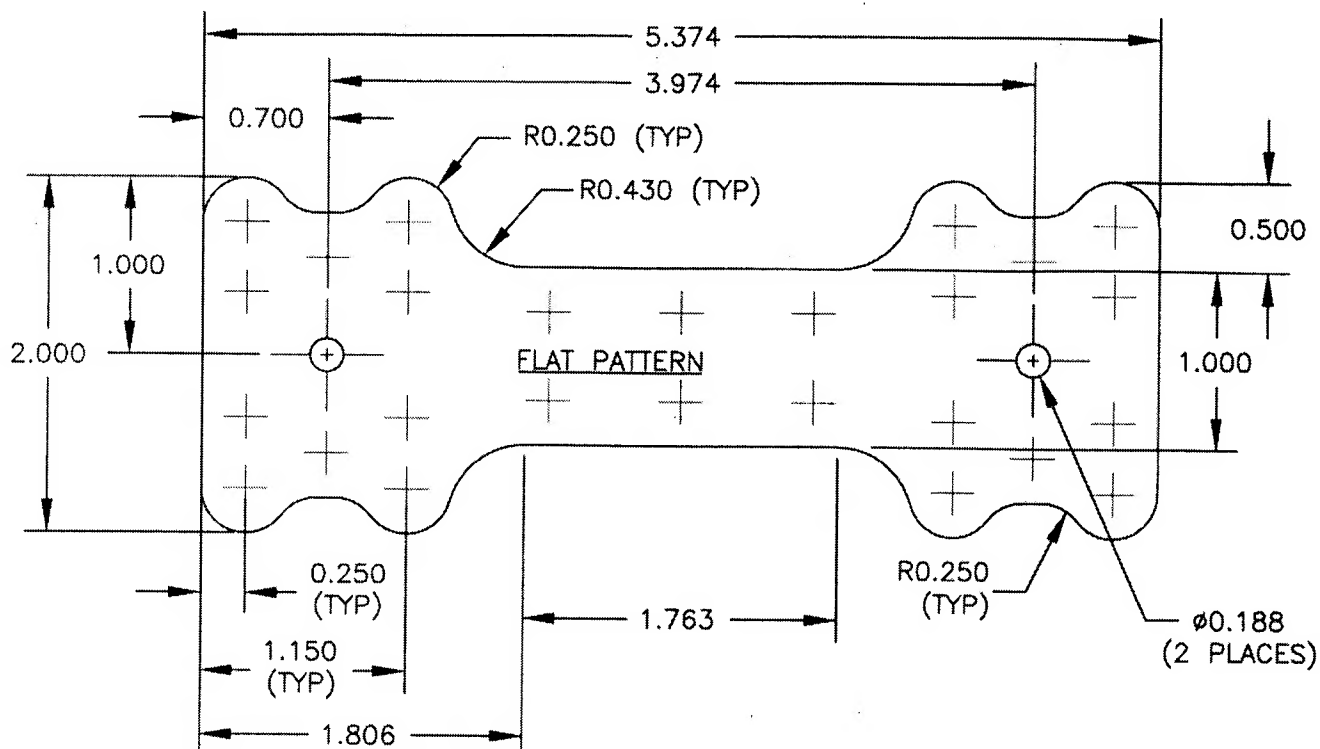
122521

(150)

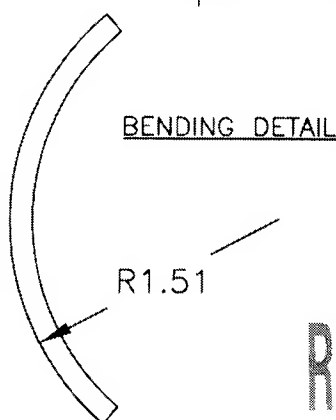




DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.



RELEASED  
04.06.22

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 91159 M65  
12-10-03

#### D3286-1 DOUBLER

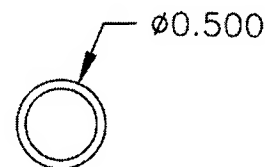
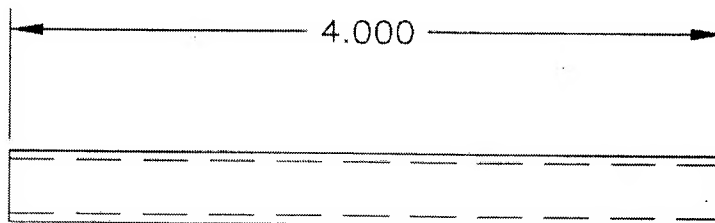
- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK  
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



**D3286-3 SPACER**

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL  
(REF DART SPEC. M304TRO.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED  
04.06.22 *H*

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